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D119-646-043
Job Sheet 166538



Part No: D119-646-043

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Wearpads, Float Compatible - Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 10/4/17

Job Tracking No:

Due Date: 10/13/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG IIN-D119-646 REV D, D3905-041 REV E SHEETS 1,2,5,6, 8-14 IPP RevA: New issue DD verified by:EC IPP revB 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:F 16.11.02 chg as per D3905 revD(DEO) DD verf:JLM IPP REV:G 17.05.23 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/12/17	0.00	0.00	Start up container	
100	DC	1 pcs	10/12/17	0.00	0.00	DC	
110	Skidtubes	1 pcs	10/12/17	0.00	3.68	Skidtubes	
120	HandFinish	1 pcs	10/12/17	0.00	1.56	HandFinish1	
130	QC	1 pcs	10/12/17	0.00	0.00	QC7	
140	QC	1 pcs	10/12/17	0.00	0.00	QC5	PD 9
170	Skidtubes	1 pcs	10/12/17	0.00	3.68	Skidtubes	3.68 DAS
180	QC	1 pcs	10/12/17	0.00	0.00	QC5	PD 9
190	Skidtubes	1 pcs	10/12/17	0.00	3.68	Skidtubes	DAS 3.68
200	QC	1 pcs	10/12/17	0.00	0.00	QC5	PD 9 DAS
210	QC	1 pcs	10/12/17	0.00	0.00	QC10	PD 3.68 9
220	HandFinish	1 pcs	10/12/17	0.00	1.56	HandFinish2	9.88
230	SprayPaint	1 pcs	10/12/17	0.00	0.42	Spray Paint	DAS
240	QC	1 pcs	10/12/17	0.00	0.00	QC14	17/10/17 15
250	HandFinish	1 pcs	10/12/17	0.00	1.56	HandFinish4	17/10/17 9-88
260	QC	1 pcs	10/12/17	0.00	0.00	QC5	
270	HandFinish	1 pcs	10/12/17	0.00	1.56	HandFinish4	17/10/17
280	QC	1 pcs	10/12/17	0.00	0.00	QC5	17/10/17
285	HandFinish	1 pcs	10/13/17	0.00	1.56	HandFinish3	17/10/17
286	QC	1 pcs	10/13/17	0.00	0.00	QC5	9
290	Packaging	1 pcs	10/13/17	0.00	0.00	Packaging3	9.88
300	QC21-FG - Give to Plex core group	1 Ea	10/13/17	0.00	0.00	QC21	M517-1027

Part Op 100 - Photocopy bluefile & type labels per PPP D119-646-043 CHG 005

Descriptions: 110 - 1- Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905 (FOLIO -04) 2- Cut FWD end of tube as per dwg D3905. 3- Cut AFT end of tube as per dwg D3905. 4- Buff out marks left from bending 5 -Install drill Jig DT9480 drill X-bolt spacer pilot holes using 3/16" drill first side only. 6- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 7- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9480 8- Drill FWD cap holes using DT8215.

170 - Open FWD Saddle holes to finish size as per dwg and deburr 1-Bond web in place as per Dwg D3905 & QSI 015.

(at 42.95" ref.) A/R Sikaflex-291 _____ Sikaflex expire date: _____ Start: _____ Time: _____

Finish: _____ Time: _____ ***** (Adhere for 12 hours) ***** 2--Bend AFT end of tube using

CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

SERIAL NO: S000404

Job #: 166538
Mfg Date: 10/12/17

AW119 Replacement Skidtube with Wearpads, Float Compatible - Fits LI

OCT17

PART NO: D119-646-043
Revision: 1
Operation: Start up operation
Quantity: 100 DC
Next Op: 100 DC

By _____

Supervisor _____

Inspector _____

Sign _____

ance _____

Root Cause

Environment ☐	No Re-verification ☐	Pressure/Forced ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wa ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : ☐

WIP

Off-set ☐	Part Moved ☐
Mislabeled ☐	Drawing ☐
Fit/Function ☐	Finish ☐
Misaligned/off center ☐	Misread ☐
	Turning Sequence ☐

Done 2/1

Parts list:

PART NO:

NAS1611-005

NAS1149C0332R

MS24694-C52

MS21043-4

D5101-5

D5101-3

D5101-047

D5101-041

D3847-11

D3847-1

D3672-1

D3482-5

D2855-3

AN4C-46A

ANU3C-5A

AN54-1032-225

AN54-1032-130

D2855-5

AN11491004165

AN3C4A

D3672-3

BATCH NO:

M137769 5001462

M137851 - 5001710

M137951

M137886-1

M158796

M158939

500033

M143449

M159114

B153503 5001468

M150071

M162345

B153291

M137316

M138441

M135992 -2

M137920

B166541

M131511

M138556

5001683

5001699

F132639

QUANTITY:

x16

x44

x2 5001304

x3 5001306

x6 5001712

x6 5001313

x1

x2 5001314

x1 5001324?

x6

x2 5001324

x16 5001328

x1 5001329

x3 5001330

x3 5001331

x1 5001332

x42

x1

x6 5001333

x6

12

position. 3- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 4- Drill Tow ring hole using DT10047. Open to finished size. 5- Open FWD & AFT cap holes per dwg. Countersink Fwd cap only as per detail "C" 6-Open crossbolt spacer holes to finished size. Drill most Fwd wearplate holes using DT9816 (15.21") 7-Debur crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube 8- Drill holes for wearpads using DT9613 & D

190 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDELING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod

2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3905. 4- Debur & Scribe batch # on Aft end of tube. 5- Pick D2855-5 cap and transfer drill missing hole. Debur and identify cap with skidtube batch#.

200 - TEST FIT USING FIXTURE DT10091.

220 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

230 - ***AS PER DETAIL"F" NOTE 8, SHEET 8 MASK THIS AREA. DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: 138402 PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: 138525**

250 - 1-Install inserts as per Dwg D3905:

270 - 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 Sikaflex expire date: 2-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 3 -Inspect for foreign objects as per QSI 024 4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291

Sikaflex expire date: 5 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 Sikaflex expire date: 6- Install (2)D5101-041 and (1) D5101-047 as per dwg by using DT10117

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2500-1-190 B 159717	1	0	0	0
170-Skidtubes	D3885-3 B154332	1	0	0	0
190-Skidtubes	D2579 B162087	2	0	0	0
	D2855-5 5000382	1	0	0	0
	D3681-1 B165379	8	0	0	0
	D3903-1 B165654	12	0	0	0
250-HandFinish	ALS4-1032-130	42	0	0	0
	D3683-3	12	0	0	0
270-HandFinish	ALS4-1032-225	1	0	0	0
	AN3C4A	6	0	0	0
	AN3C5A	38	0	0	0
	AN4C46A	3	0	0	0
	D2855-3	1	0	0	0
	D3492-5	16	0	0	0
	D3672-1	2	0	0	0
	D3672-3	12	0	0	0
	D3847-1	8	0	0	0
	D3847-11	1	0	0	0
	D5101-041	2	0	0	0
	D5101-047	1	0	0	0
	D5101-3	6	0	0	0
	D5101-5	6	0	0	0
	MS21043-4	3	300	0	0
	MS24694-C52	2	100	0	0
	MS27039C4-08M126319	12	0	0	0
	NAS1149C0332R	44	0	0	0
	NAS1149C0463R M12732615	12	0	0	0
	NAS1611-005	16	0	0	0

500170G -

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Traveller Change Request

Part#: _____

Job#: _____

Name _____

Date _____

Workcenter _____

Operation # _____

Issue:

Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested: _____

Name _____

Date _____

Workcenter _____

Operation # _____

Issue:

Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Name _____

Date _____

Workcenter _____

Operation # _____

Issue:

Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested: _____

D119-646-043 REV.E B

Seq.; 110

1- Bend FWD end of tube using Bender 1 and bend prog. D3905 FWD per dwg. D3905 (FOLIO -04)

2- Cut FWD end of tube as per dwg D3905.

3- Cut AFT end of tube as per dwg D3905.

4- Buff out marks left from bending

5 -Install drill Jig DT9480 drill X-bolt spacer pilot holes using 3/16" drill first side only.

6- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes.

7- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9480

8- Drill FWD cap holes using DT8215.

Seq120; Alodine

Seq.; 130 Qc7

BE 17-10-10

Seq.; 140 Qc5

BE 17-10-10

Seq.; 170

Open FWD Saddle holes to finish size as per dwg and deburr

1-Bond web in place as per Dwg D3905 & QSI 015. (at 42.95" ref.)

A/R

Sikaflex-291

138535

15.30 HR

Sikaflex expire date:

2018-04-21

REFERENCE ONLY

Start: _____ Time: _____

Finish: _____ Time: _____

***** (Adhere for 12 hours) *****

2- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web position.

3- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg.

4- Drill Tow ring hole using DT10047. Open to finished size.

5- Open FWD & AFT cap holes per dwg. Countersink Fwd cap only as per detail "C"

6- Open crossbolt spacer holes to finished size. Drill most Fwd wearplate holes using DT9816 (15.21")

7- Deburr crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube

8- Drill holes for wearpads using DT9613 & DT9545 open to 0.297". Deburr.

9- Buff out marks left from bending.

10- Pilot drill and Open holes of section G using DT9493 open to finished size.

11- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

Seq.: 180 Qc5

BE 17-10-12

- clean tube

Seq.: 190

MGS
17/10/11

NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE,IF
FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091.

1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole
before welding the other side. Use aluminum rod

A/R

Aluminum Rod

M137133

BE17-12

2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole.

3-Counterbore 5/16" x 0.750" deep as per Dwg D3905.

17/10/12

4- Deburr & Scribe batch # on Aft end of tube.

START 1:15 P.M

5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.

Seq.: 200 Qc5

Seq.: 210 Qc10

Seq.: 220

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

Seq.: 230

*****AS PER DETAIL "F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT*****

PRIME AS PER DWG AND QSI 005 4.2

BATCH: _____

PAINT WHITE AS PER DWG AND QSI 005 4.2

BATCH: _____

Seq.; 240 QC14

Seq.; 250

1-Install inserts as per Dwg D3905.

Seq.; 260 Qc5

Seq.; 270

1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers

A/R Sikaflex-240/-291 M138535 *see 17/10/16*
Sikaflex expire date: 18/04

2-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M1135477

3 -Inspect for foreign objects as per QSI 024

4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-240/-291 M138535 *see 17/10/16*
Sikaflex expire date: 18/04

5 -Install insert in D2855- Cap.

Install cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-240/-291 M138535 *see 17/10/16*
Sikaflex expire date: 18/04

6- Install (2) D5101-041 and (1) D5101-047 as per dwg by using DT10117

Seq.; 280 Qc5

Seq.; 285 Wing Walk

Seq.; 286 Qc5

Seq.; 290 Packaging

Seq.; 300 Qc21

11138373 all 17/10/16

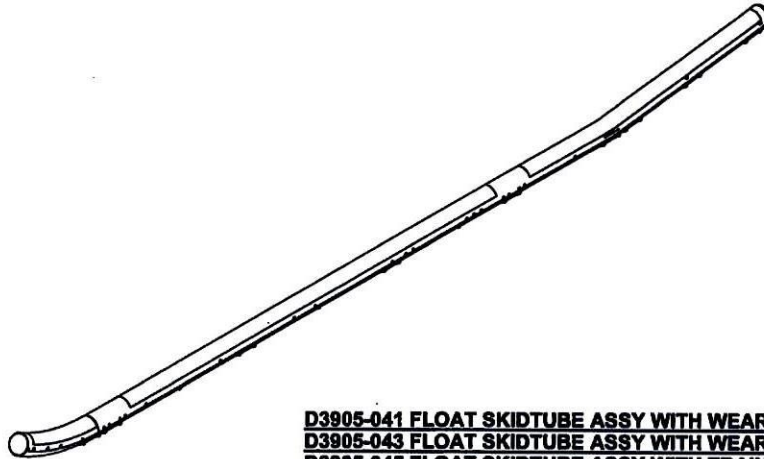
Status	Item ID	Rev	Name	Start Date	Quantity	PeUOM	Scrap %	Route Seq	ILComment	Sort	ate Last Mo	Add Date	Stop Date
	NAS1611-005		O-RING	4/20/2011	16.0000	E...	0 %	270		5	3/20/20...	4/20/...	
	NAS1149C0463R		Washer	3/20/2013	12.0000	E...	0 %	270		19	2/13/20...	3/20/...	
	NAS1149C0332R		WASHER	3/20/2013	44.0000	E...	0 %	270		18	2/13/20...	3/20/...	
	MS27039C4-08		SCREW	6/25/2009	12.0000	E...	0 %	270		20	3/20/20...	12/5/...	
	MS24694-C52		SCREW	3/20/2013	2.0000	E...	0 %	270		21	2/13/20...	3/20/...	
	MS21043-4		Nut	1/19/2015	3.0000	E...	0 %	270		0	1/19/20...	1/19/...	
	D5101-5		Insert	1/19/2015	6.0000	E...	0 %	270		0	1/19/20...	1/19/...	
	D5101-3		Insert	1/19/2015	6.0000	E...	0 %	270		0	1/19/20...	1/19/...	
	D5101-047		Crossbolt Spacer Assembly	11/2/2016	1.0000	E...	0 %	270		0	11/2/20...	11/2/...	
	D5101-041		Crossbolt Spacer Assembly	1/19/2015	2.0000	E...	0 %	270		0	11/2/20...	1/19/...	
	D3903-1		Spacer	12/5/2009	12.0000	E...	0 %	190		13	3/20/20...	12/5/...	
	D3885-3		Float Web	12/5/2009	1.0000	E...	0 %	170		12	3/20/20...	12/5/...	
	D3847-11		Wearpad	12/5/2009	1.0000	E...	0 %	270		11	3/20/20...	12/5/...	
	D3847-1		Wearpad	12/5/2009	8.0000	E...	0 %	270		10	3/20/20...	12/5/...	
	D3683-3		Insert	12/5/2009	12.0000	E...	0 %	250		15	3/20/20...	12/5/...	
	D3681-1		Spacer	12/5/2009	8.0000	E...	0 %	190		7	3/20/20...	12/5/...	
	D3672-3		Washer, Phenolic	3/20/2013	12.0000	E...	0 %	270		14	2/13/20...	3/20/...	
	D3672-1		Washer, Phenolic	12/5/2009	2.0000	E...	0 %	270		6	3/20/20...	12/5/...	
	D3492-5		Plug	4/20/2011	16.0000	E...	0 %	270		4	3/20/20...	4/20/...	
	D2855-5		Cap	5/23/2017	1.0000	E...	0 %	190		0	5/23/20...	5/23/...	
	D2855-3		Cap	12/5/2009	1.0000	E...	0 %	270		3	5/23/20...	12/5/...	
	D2579		Crossbolt Spacer	11/5/2012	2.0000	E...	0 %	190		2	2/13/20...	11/5/...	
	D2500-1-190		Ext'n - 'I' Beam Tube 4"	12/5/2009	1.0000	E...	0 %	110		1	12/5/20...	12/5/...	
	AN4C46A		Bolt	1/19/2015	3.0000	E...	0 %	270		0	1/19/20...	1/19/...	
	AN3C5A		Bolt	6/25/2009	38.0000	E...	0 %	270		17	11/2/20...	12/5/...	
	AN3C4A		Bolt	11/2/2016	6.0000	E...	0 %	270		0	11/2/20...	11/2/...	
	ALS4-1032-225		Rivnut	5/23/2017	1.0000	E...	0 %	270		0	5/23/20...	5/23/...	

Item ID: D119-646-043

BOM Type: Production

Status	Item ID	Rev	Name	Start Date	Quantity	Per UOM	Scrap %	Route Seq	II Comment	Sort	ate Last Mo	Add Date	Stop Date
	ALS4-1032-130		Rivnut	6/25/2009	42.0000	E...	0 %	250		16	3/20/20...	12/5/...	

REFERENCE ONLY



D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

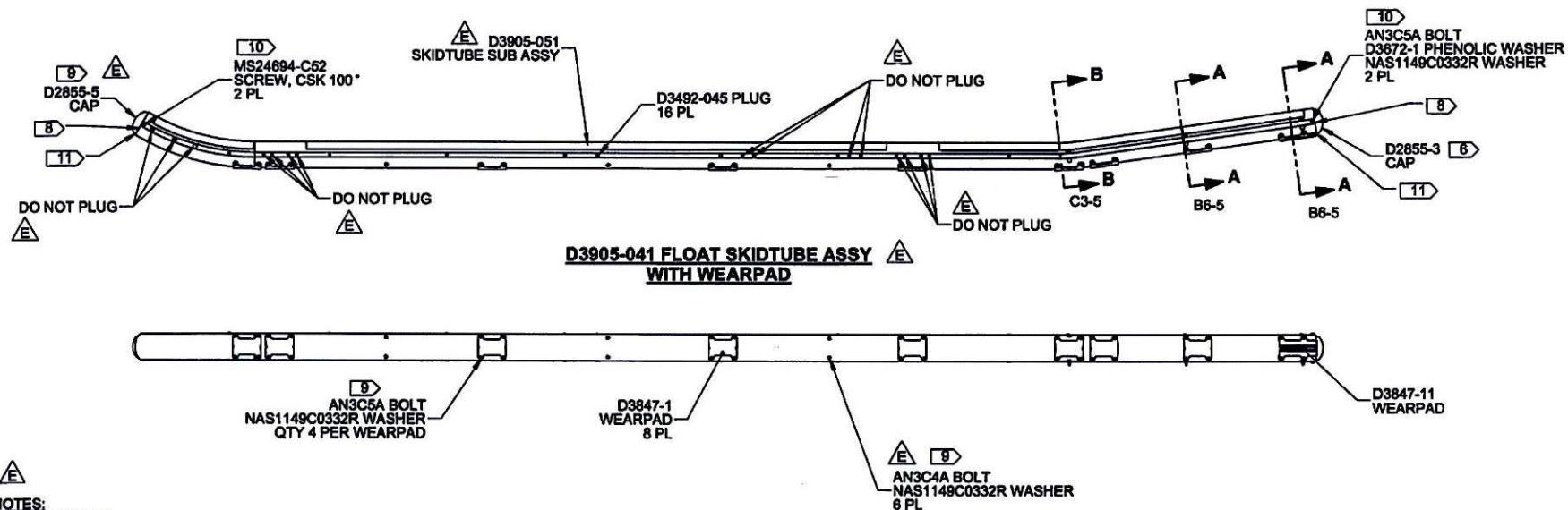
E	COMPLETE REDRAW SEE PREVIOUS REV. AFT FLOAT HOLE NOW Ø0.465 WAS Ø0.437 FINISH REMOVED FROM SADDLE AREA SEE DETAIL F. REF PART15-421 CHANGE QTY OF D2855-3, ADDED D2855-5 CAP ASSEMBLIES, ADDED INSTRUCTIONS TO LOCATE INSERT HOLE FOR D2855-5 CAP. REF PART17-583 ADDED DRILL JIG REF NUMBER, NOR15-5366 INCREASE RIDGE RELIEF FROM 0.090 TO 0.130. REF PART17-574		AJS / WK	17.03.13
D	REVISED DIMENSIONS AND PROVIDED TOLERANCE TO SKIDTUBE OVERALL LENGTH PAGE 5-8 REVISED NOTE 2 AND NOTE 7 PAGE 1 (ZN B6, ZN A8-1) REVISED -041/-043/-045 DRAWING VIEWS, REVISED SECTION VIEW F-F (ZN B4-7), REVISED BOM REF. PART13-299 AND PART13-272		AK	14.08.08
C	(SHT 1 PL. ZN C2-2, C2-3, C2-4) ITEM 13, QTY 2 WAS 4, ITEM 42 AND 43, QTY 44 WAS 46, ADD ITEM 48, MS24894-C52 WAS AN3C5A, D3872-1 AND NAS1149C0332R, (ZN C7-7) Ø0.201 CSK Ø0.385 X 100" WAS Ø0.204 THRU, (ZN A4-5, A4-6) ADD RELIEF INSTRUCTION, ADD ITEM 10, CROSS BOLT SPACER (ZN D4-1, C5-7, D6-7)		DB	13.02.21
B	REVISED PART LIST, AL54-1032-130 WAS AELS-1032-130 (ZN A5-5, A5-6, C5-7, A5-7); ADD DT8832 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C5-3, C1-3, C6-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); Ø0.313 WAS Ø0.328 (B2-5, B2-6, C2-7, A5-7 & D7-5), REVISED NOTE IV (ZN A8-7)		RF	09.06.30
A	NEW ISSUE		RF	09.03.30
REV.	DESCRIPTION		BY	DATE
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DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS	
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3905-041	SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	8	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3905-051	SKIDTUBE SUB ASSEMBLY
8	2	D5101-041	CROSSBOLT SPACER ASSY
9	1	D5101-047	CROSSBOLT SPACER ASSY
10	6	D5101-3	INSERT
11	6	D5101-5	INSERT

ITEM	QTY -041	P/N	DESCRIPTION
12	1	ALS4-1032-225	INSERT
13	6	AN3C4A	BOLT
14	38	AN3C5A	BOLT
15	3	AN4C46A	BOLT
16	3	MS21043-4	NUT, SELF-LOCKING
17	2	MS24694-C52	SCREW, CSK 100°
18	44	NAS1149C0332R	WASHER
19	6	NAS1149C0416R	WASHER



**D3905-041 FLOAT SKIDTUBE ASSY
WITH WEARPAD**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-041" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 35.4 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\phi 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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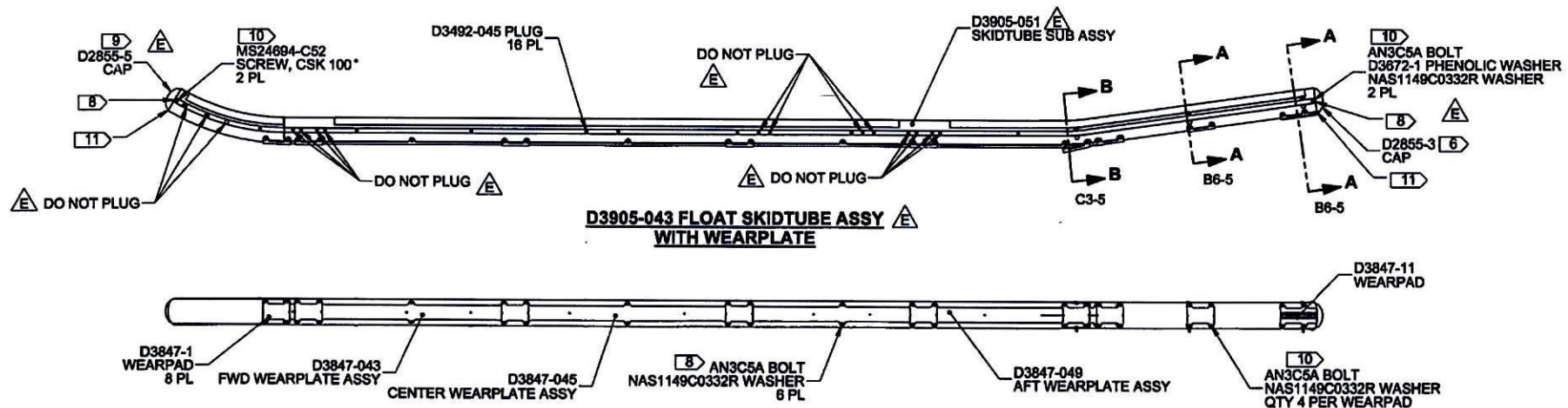
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DE APPR.	DS	SCALE NTS
DATE	17.03.13	

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ITEM	QTY -043	P/N	DESCRIPTION
	X	D3905-043	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	PLUG
4	2	D3872-1	PHENOLIC WASHER
5	1	D3847-043	FWD WEARPLATE ASSY
6	1	D3847-045	CENTER WEARPLATE ASSY
7	1	D3847-049	AFT WEARPLATE ASSY
8	8	D3847-1	WEARPAD
9	1	D3847-11	WEARPAD
10	1	D3905-051	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSSBOLT SPACER ASSY
13	6	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY -043	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	44	AN3C5A	BOLT
17	3	AN4C48A	BOLT
18	3	MS21043-4	NUT, SELF-LOCKING
19	2	MS24694-C52	SCREW, CSK 100°
20	44	NAS1149C0332R	WASHER
21	6	NAS1149C0416R	WASHER



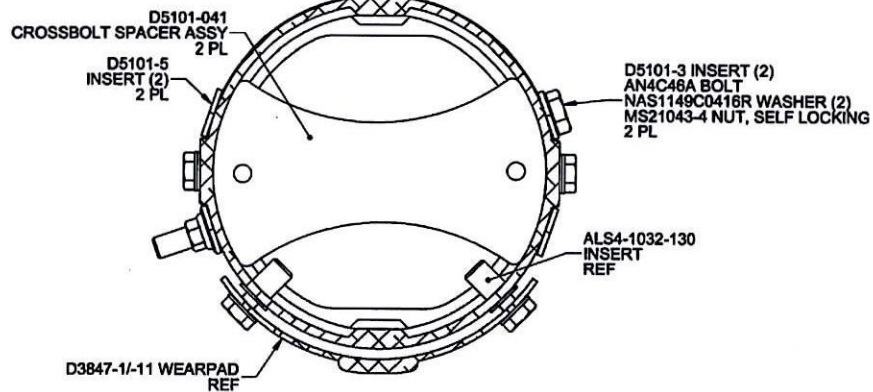
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-043" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 42.8 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\varnothing 0.297$. ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

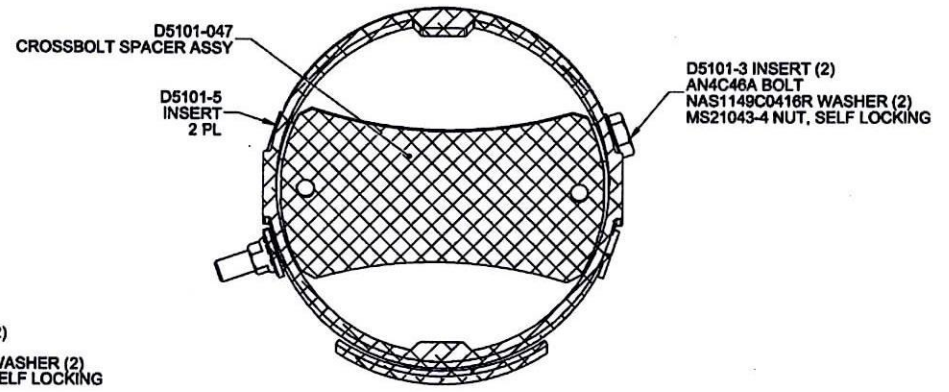
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SECTION A-A
SCALE: 12X



SECTION B-B
SCALE 12X

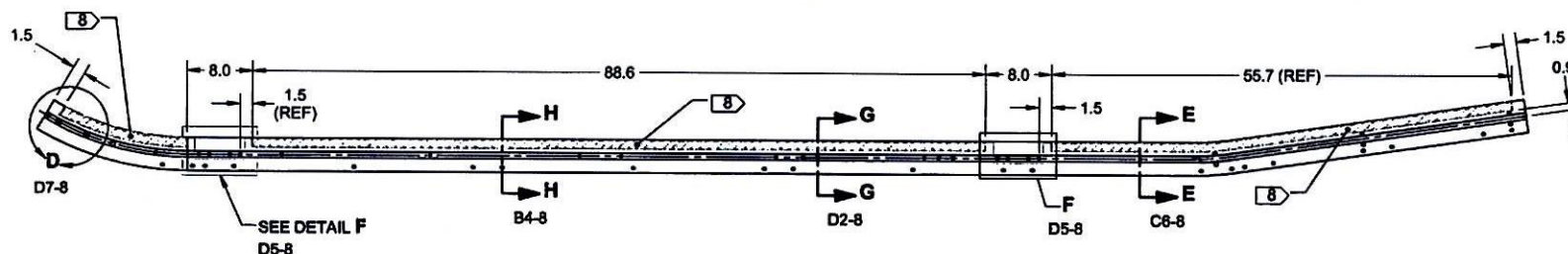
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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-051	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-081	SKIDTUBE SUB ASSEMBLY
5	42	ALS4-1032-130	INSERT



D3905-051 SKIDTUBE SUB ASSEMBLY

NOTES:

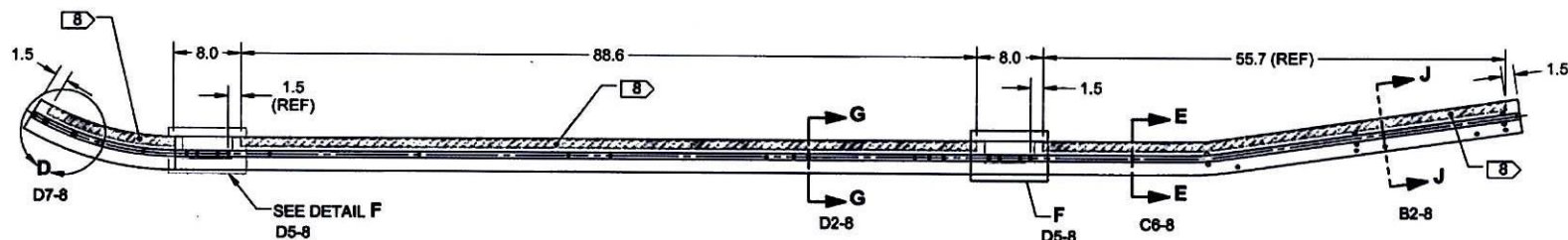
- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-053	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-063	SKIDTUBE SUB ASSEMBLY
5	10	ALS4-1032-130	INSERT



D3905-053 SKIDTUBE SUB ASSEMBLY

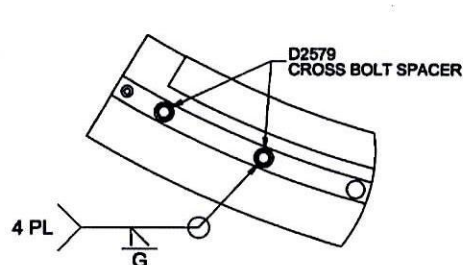
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

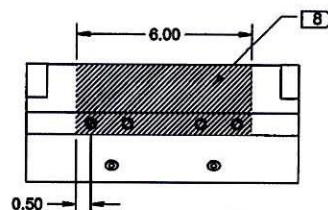
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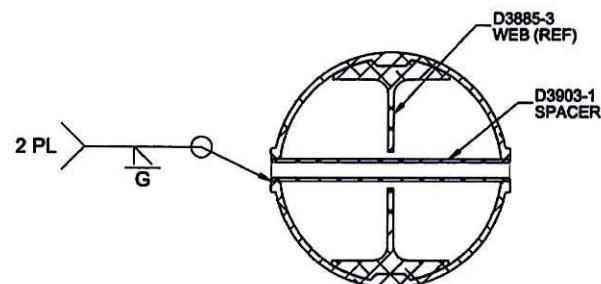
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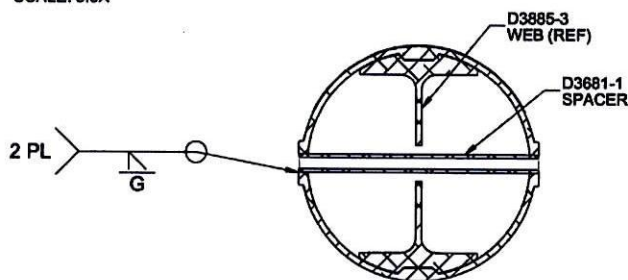
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SCALE: 3.5X



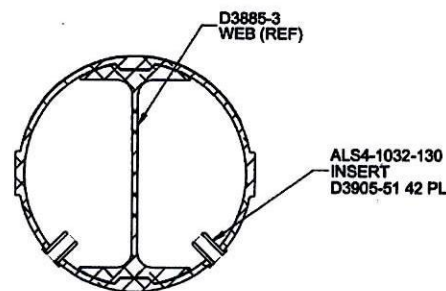
DETAIL F
SCALE: 3.5X



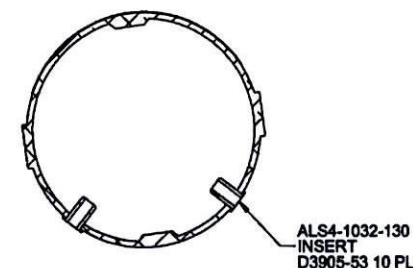
SECTION G-G
SCALE: 7X
12 PL



SECTION E-E
SCALE: 7X
8 PL



SECTION H-H
SCALE: 7X
D3905-51 21 PL



SECTION J-J
SCALE: 7X
D3905-53 5 PL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) MASK THIS AREA AND DO NOT APPLY PRIMER OR PAINT
- 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION G-G $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) CBORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3681-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
- 11) WELD PER DART QSI 004

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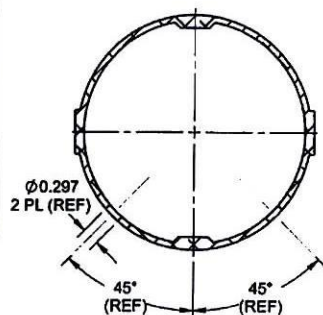
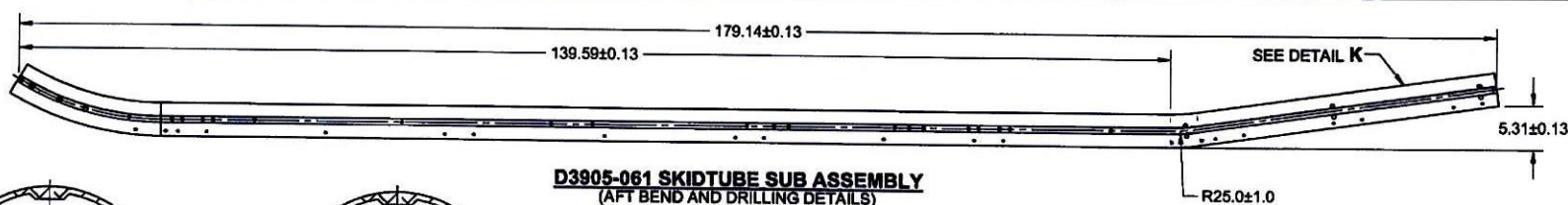
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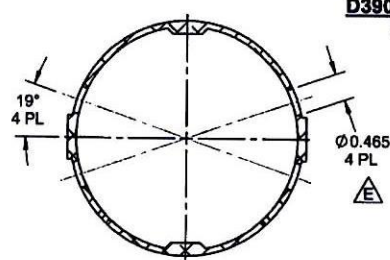
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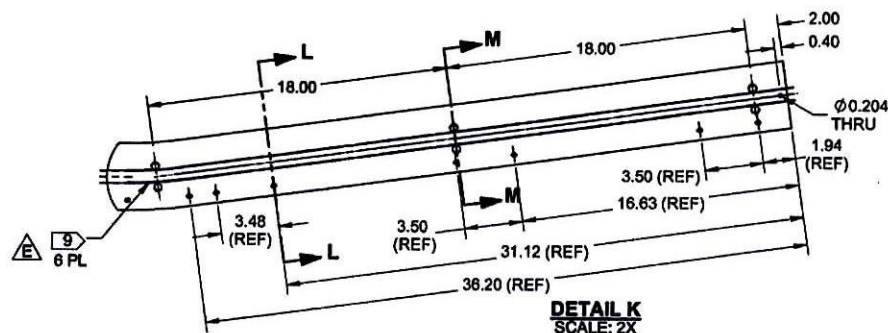
ITEM	QTY	P/N	DESCRIPTION
		D3905-061	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-11	SKIDTUBE



SECTION L-L
7 PL
SCALE: 7X



SECTION M-M
3 PL
SCALE: 7X



DETAIL K
SCALE: 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 016 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

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2017-05-08

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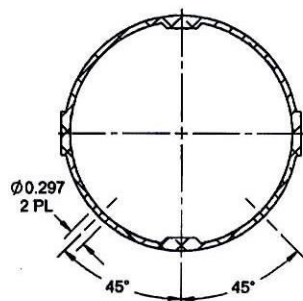
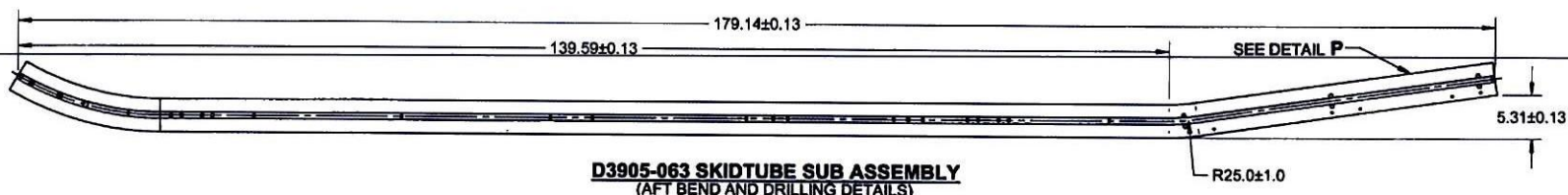
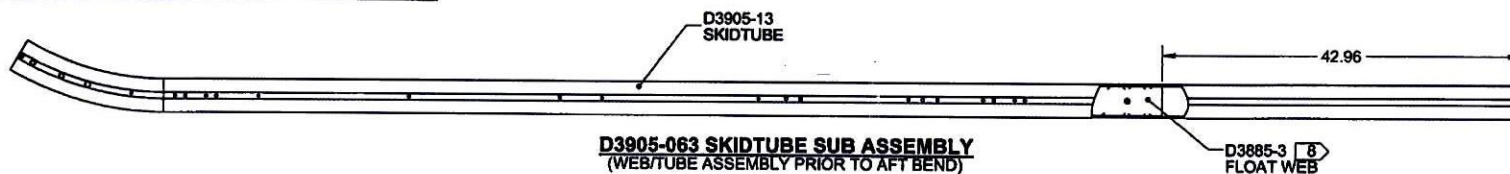
DESIGN	AJS
DRAWN	WK
CHECKED	VS
MFG. APPR.	DD
APPROVED	HS
DE APPR.	DS
DATE	17.03.13

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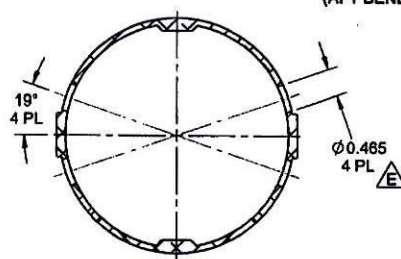
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D3905	SHEET 9 OF 14
TITLE	SCALE
A119 FLOAT SKIDTUBE ASSY	NTS

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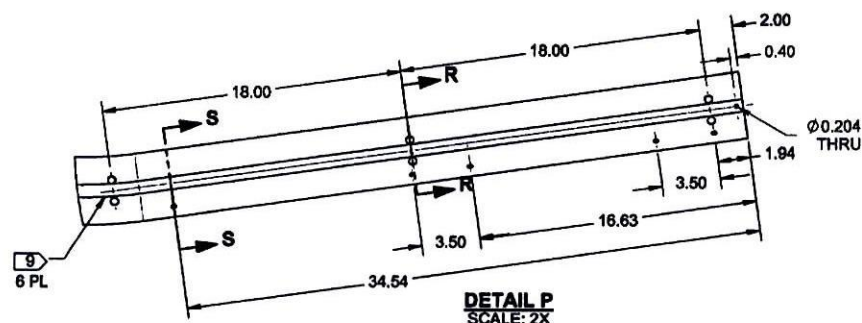
ITEM	QTY	P/N	DESCRIPTION
	X	D3905-063	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-13	SKIDTUBE



SECTION S-S
5 PL
SCALE: 7X



SECTION R-R
3 PL
SCALE: 7X



DETAIL P
SCALE: 2X

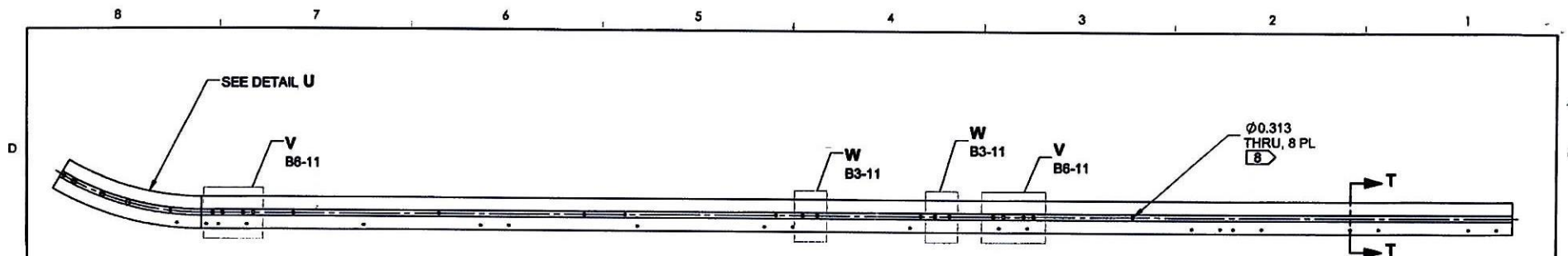
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

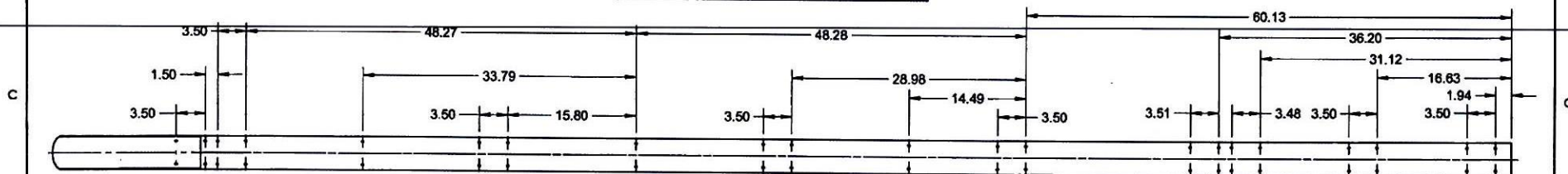
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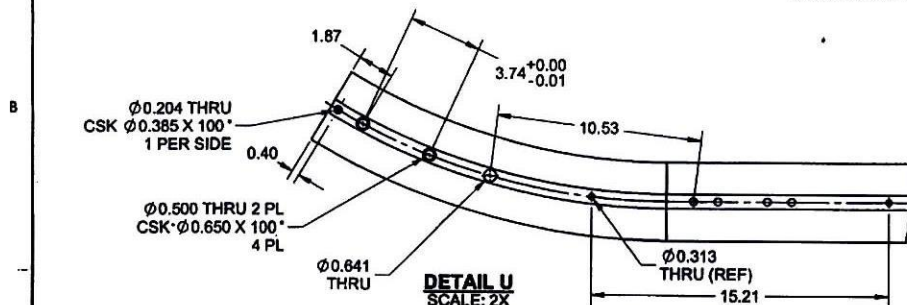
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APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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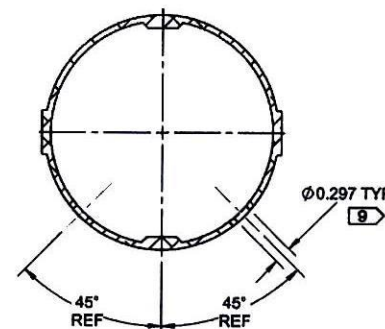
D3905-11 SKIDTUBE DRILLING DETAIL



WEARPAD/WEARPLATE HOLE PATTERN
FOR REFERENCE ONLY
DRILL USING DT9613/DT9545 TEMPLATE



DETAIL U
SCALE: 2X



SECTION T-T
SCALE: 2X
21 PL



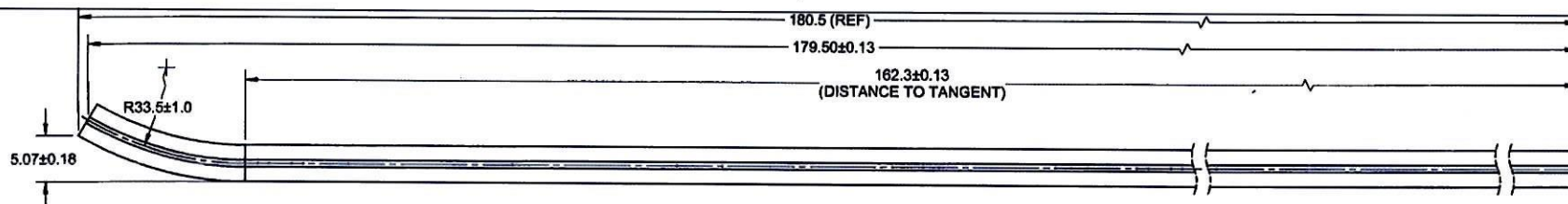
NOTES:

- 1) MATERIAL: MAKE -11 DRILL DETAIL FROM -1 FWD BEND DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) PICK UP ON PILOT HOLES
- 9) USE DART DRILL TEMPLATE DT9613/DT9545 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPAD/WEARPLATE INSERTS.

RELEASED
2017-05-08

APPROVED

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CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 11 OF 14
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D3905-1 SKIDTUBE FWD BEND DETAIL

NOTES:

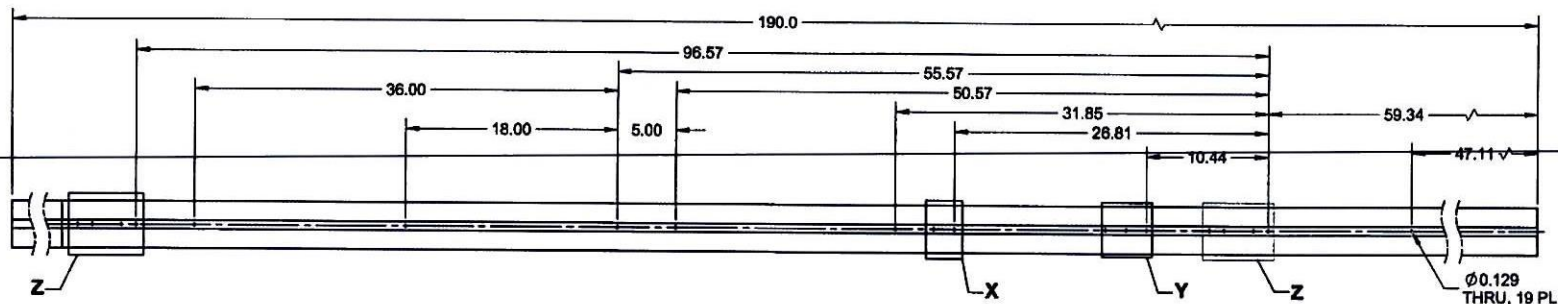
- 1) MATERIAL: MAKE -1 FWD BEND DETAIL FROM -3 PILOT HOLE DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

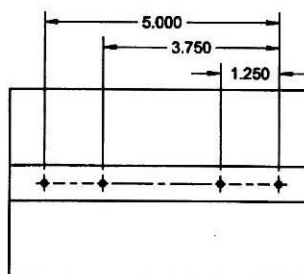
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2017-05-08

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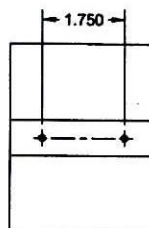
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MFG. APPR.	DD	D3905	SHEET 13 OF 14
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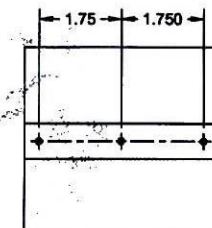
D3905-3 SKIDTUBE PILOT HOLE DETAIL



DETAIL Z
SCALE: 4X



DETAIL X
SCALE: 4X



DETAIL Y
SCALE: 4X

NOTES:

- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

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2017-05-08

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